

Split

Work Order ID 58205-2

Thursday, April 29, 2010 10:36:43 AM



Item ID: D3637-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

12

Start Date: 4/29/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-4-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3637

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B10-4-29

304 .080

(14)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B10-4-29

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S104130

(14)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Page 2

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3637

0.00

0.00

80 10/04/03

14

8

140



Small Fab

Small Fab

Small Fab

Memo

1- drill holes as per dwg using DT8979 2-C'Sink as per Dwg D3637 3-
Install Nut plate as per Dwg D3637

0.00

0.00

7 M-L 10/05/10

12X

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

10/05/10

412

W/O:		WORK ORDER CHANGES					
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Page 3

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: 244A

0.00

Memo

0.00

PO 10/5/11 (12)

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/12 (12)

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Picklist Print

Thursday, April 29, 2010 10:36:42 AM

Page 1

Work Order ID: 58205

Parent Item: D3637-041

Parent Item Name: Bracket Assembly

Start Date: 4/29/2010

Required Date: 5/14/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------



Rivet

Location

Loc Qty

Loc Code

ST316

5068

19099

4774

7681 ✓

294

M304S14GA

Purchased

No

140

sf

138.6608

0.09



304SS sheet .080

Location

Loc Qty

Loc Code

MAT20

138.6608

113295

138.6608

MS21059L4

Purchased

No

140

Each

37.0000

1



Nutplate

Location

Loc Qty

Loc Code

ST302

37

112243 ✓

37

28 m-k 10/05/10

2.0 1810-4-29

(14)

113295

14x m-k 10/05/10

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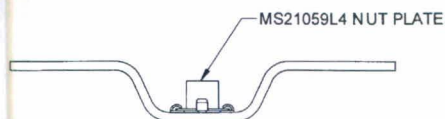
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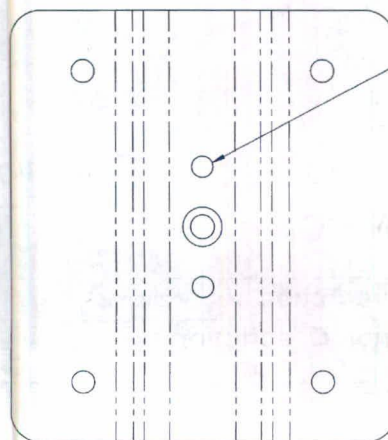
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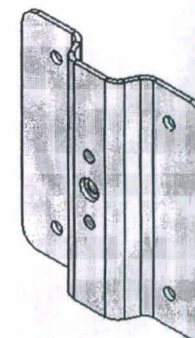


MS21059L4 NUT PLATE



MS20426AD3-3 RIVET
(2 PLACES)

D3637-1 BRACKET



458205

D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

B	FOR D3637-1, 1 15 WAS 1 30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	AF		
MFG. APPR.	EP		
APPROVED	EP		
DE APPR.			
DATE	07.12.18		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3637 TITLE BRACKET REV. B SHEET 1 OF 3 SCALE 1:1 <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

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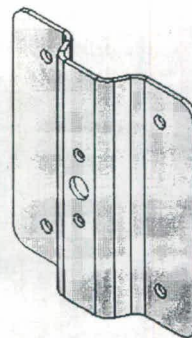
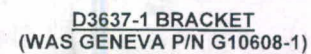
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1) MATERIAL: AL 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059
(REF DART SPEC M304S14GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.26 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	ME	D3637	SHEET 2 OF 3
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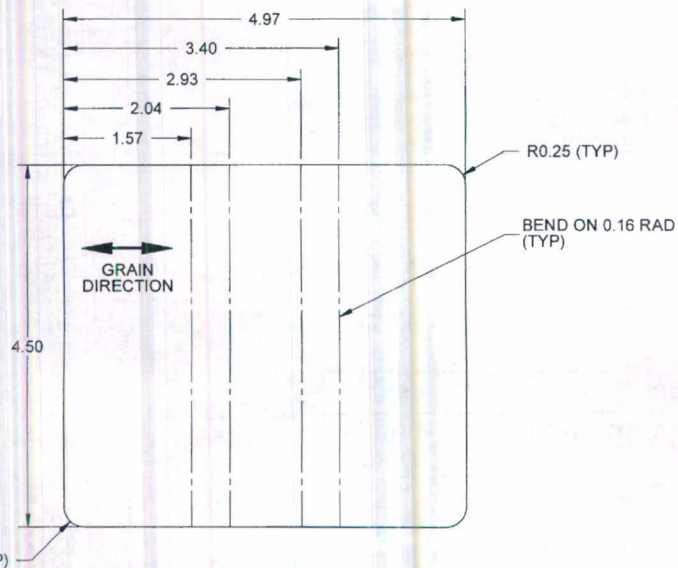
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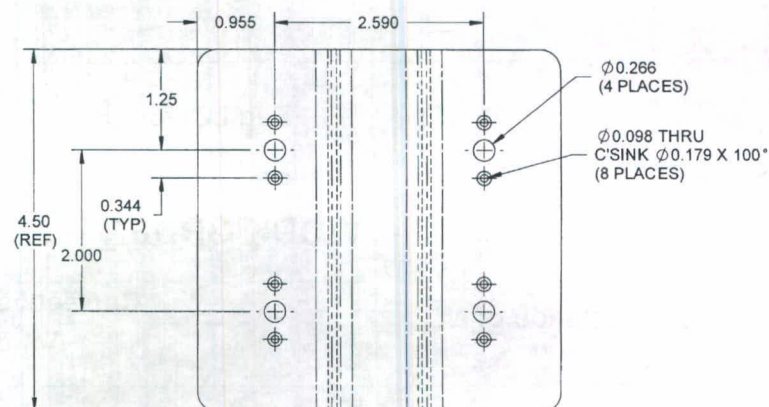
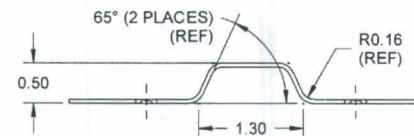
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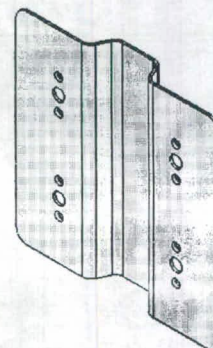
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D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

#58203

RELEASED
08-22-05

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	EF	DRAWING NO.	REV. B
MFG. APPR.	ED	D3637	SHEET 3 OF 3
APPROVED	EF	TITLE	SCALE
DE APPR.	EF	BRACKET	2:3
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